

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009668**Date Inspected:** 16-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qie wen/ Mr. Chen ying xin			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Trial assembly area

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040675 perform SMAW welding on, Skin A, connection plate, East tower, lift 1. The weld joint identified as ESD1-SA 107 C/J-4. ZPMC CWI Identified as Mr. Ye yong jun . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2114.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 20497 perform FCAW welding on, Skin E, Hand rail connection, East tower, lift 1. The weld joint identified as E 74-ESD1-E-28M-123. ZPMC CWI Identified as Mr. Ye yong jun . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Machining area

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067609 perform SMAW welding on, Rib plate, inside East tower, lift 3 in between 89 mtr. Double diaphragm. The weld joint identified as ESTL3-4C/K-103. ZPMC CWI Identified as Mr. An qing xiang . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-U2A.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 067571 perform SMAW surface repair welding on, Skin E, inside south tower, lift 3 on 89 mtr. Elevation diaphragm plate. ZPMC CWI Identified as Mr. Wan wen zhong . The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) - repair.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as East tower, Lift 3,111.89 mtr. Elevation fit lugs, Diaphragm to skin A,B,C,D &E. The weld designations reviewed are as follows:

ESTL 3-4 J/K- Jt. no. 35, 39, 41, 47, 51, 53, 56, 66, 71, 7, 9, 21,25,27,31–East, Lift 3 – 111.89mtr.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
